Work Order ID 76734 *76734* Page 1 November 21, 2011 9:25:58 AM Item ID: D3250-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Back **Start Date:** 11/21/11 Start Qty: 2.00 **Cust Item ID:** Required Date: 11/29/11 **Req'd Qty: 2.00 Customer:** Reference: Run Process Plan: Approvals: Date: QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description Code Qty **Qty** Number Stamp **Run Hours Draw Nbr Revision Nbr** D3250 Rev C 100 0.00 **PURCHASING** *100* 1B11-11-21 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg Prog Rev: 2-Deburr if necessary H311-11-21 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* QC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check *120* QC Memo

Quality Control

Dart Aerospace Ltd

Duit Aci	Johnso	M. G							
W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
		esolution:							
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NCF	₹)			
DATE	OTED	Description of NC	ļ	Corrective Action Section B			ation	Approval	Approval
DATE	STEP	Section A	Initial Action Descr Chief Eng Chief Eng		Sign & Date	& Section C		Chief Eng	QC Inspector
	1 1				ı	t		ļ	1

NOTE: Date & initial all entries

Work Order ID 76734 *76734* Page 2 November 21, 2011 9:25:58 AM D3250-1 Accept *N900040100* Setup Start Item ID: Revision ID: Item Name: Back Start Qty: 2.00 **Start Date:** 11/21/11 **Cust Item ID:** Required Date: 11/29/11 **Req'd Qty:** 2.00 **Customer:** Reference: Run **Tooling:** Process Plan: Date: Date: **Approvals:** Stop SPC (Y/N): Date:_____ Date: Reject Reject Tool ID Tool # Plan Accept Insp. Operation Set Up/ Sequence ID/ Number Stamp Qty Code Oty Work Center ID Description **Run Hours** 0.00 130 Bend as per dwg Small Fab *130* SB ululaz Brake NC 0.00 Memo Brake NC 140 QC5- Inspect part completeness to step on W/O d uluizz *140* 0.00 QC Memo Quality Control Chemical Conversion Coat per QS1005 4.1 0.00 150 *150*

0.00

Memo

HandFinish

Hand Finishing

Da	rt	Ae	ros	spa	ce	Ltd
----	----	----	-----	-----	----	-----

Dail AC	lospace Liu	•				_		
W/O:			WORK ORDER	CHANGES	<u> </u>			
DATE	STEP	PR	OCEDURE CHANGE	В	y Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							,	
			11. W. ARLANDS WAVE					
			•					
Part No	:	PAR #:	Fault Category:	NCR: \	es No D	QA:	Date: _	
	Resolution	n:	Disposition:	QA: N/	C Closed: _		Date: _	
NCR:			WORK ORDER NON-CON	IFORMANCE (N	ICR)			
							T	1

NCR:		`	WORK ORDI	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
, , .								

NOTE: Date & initial all entries

Work Orde November 21, 20				*767	34*				Page 3
Item ID: Revision ID: Item Name:	D3250-1 Back			Accept	*N90004	10100	* Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date:	11/21/11 11/29/11	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID: Customer:				
Approvals:	Process Pla		Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 160 *160* Powdercoat Powder Coating	, (5127	Operation Description Black Sandtex(Ref:4.3.5 Memo START TIM	1:45	Set Up/ Run Hours 0.00 0.00 OVEN TEMPERATURE:	Tool ID To	ol # Plan Code	Accept Re Qty Qt	-	Reject Insp. Number Stamp
170 *170* QC Quality Control		QC3- Inspect Part Finish Memo		0.00		é	2_B	2 11-11	428.
180 *180* Packaging		Identify as per dwg & Sto	ock Location 44	0.00		-	nluk	1 28 J	12

Memo

Packaging

Duit Ac	ospace i	LU							
W/O:			W	ORK ORDER CHAN	GES	<u> </u>			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	s No DQ	A:	Date: _	
	Res	solution:	Dispositio	n:	QA: N/C	Closed:		Date: _	
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NO	CR)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Se Action Description Chief Eng	ection B Sig	1& Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Criter Eng					
·									

NOTE: Date & initial all entries

Work Ord November 21, 2				*767	734*							Page 4
Item ID: Revision ID: Item Name:	D3250-1			Accept	*N900	040	100	ገ*	Setup	Start Stop	1.7	S1* S2*
Start Date: Required Date: Reference:	11/21/11 : 11/29/11	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item 1 Customer:	ID:						
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 190 *100* QC Quality Control	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	t Re Qt	•	Reject Number	29 A)

W/O:			WC	RK ORDER CHANG	GES				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A:	Date:	
	Rese	olution:	Disposition	1:	QA: N/C (Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Action Description	etion B	& Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date	B			
							·		

NOTE: Date & initial all entries

Picklist Print

November 21, 2011 9:25:58 AM

Work Order ID:

76734

Parent Item:

D3250-1

Parent Item Name:

Back

Start Date: 11/21/11

Required Date: 11/29/11

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP B 04.10.26 D3250-1 no longer made in-house

IPP Rev:C As per Rev C 06-03-07 JLM

IPP REV:D 11.11.21 MADE IN

HOUSE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	33.5000	2.902	6.109473	37		
2024-T3 .063 sheet										β	41-11-3		
				Location		Loc Qty	Lo	c Code		•			
				MAT022		33.5					/	5	
				1173	192	33.5			1(13	<u> </u>	(

Page 1

W/O:			W	ORK ORDER CHANG	ES		-		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							A	*	
					· · · · · · · · · · · · · · · · · · ·	-11-12-1-1-1-1			
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition	n:	_ QA: N/C (Closed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	on B Sign	& Verific		Approval Chief Eng	Approval QC Inspector
		3300077	Chief Eng	Chief Eng	Dat	e			
							,		
							•		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: フレフ39	
Description:	Part Number:	
Inspection Dwg: Rev:	Page 1 of	1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension	rtocopt	Rojoot	Inspection	Comments
19.902	4 ,010	1 19902	>		11301	
21.000	7 .010	121,600	>		7	
4.78	4 .036	4778	>		VIBOS	
2.19	7 .00	2.192	2		V	
3,00	7 .336	3,542	8		V	
4.00	4 .030	3,998	\$		V .	
3,∞	4 .030	2.999	>		V	
5,00	47 ,030	5,000	7		V	
3.94	4 830	3.946	2		V	
3,00	7 .030	2.996	>		V	
4.00	7 .030	4.00			V	
5,34	-y030	5,348	7		V	
5.00	7 -030	5,002	2		V	
6.00	1 .030	6.001	5		V	
3.34	1 .36	3.343	8		V	
6.34	1 ,36	6.247	7		V	
1063	1 010	1061	7		V	
				\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		
			ļ			
					`	
. 340						

Measured by:	Audited by:	Preliminary Approval:	
Date: (1-11-2(Date: Wulz	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	
			<u> </u>	

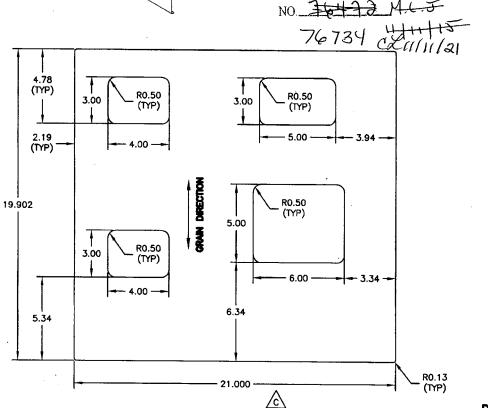
N 10.04.15

DART

			No. of the second secon				
DES	RF	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHE	CKED	APPROVED	DRAWING NO. REV. C D3250 SHEET 1 OF 1				
DATI	E		TITLE SCALE				
06	.02.01		BACK (DUAL BATTERY RACK) 1:6				
A		04.04.06	NEW ISSUE				
В		04.11.04	20.625 WAS 20.243				
C		06.02.01	21.000 WAS 20.625, REMOVE Ø0.501				
			TOOLING HOLES				

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

RELEASE 06.02.13



19.56 R0.188 0.50 (REF)

D3250-1 BEND DETAIL

D3250-1F FLAT PATTERN

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

	. Johasi									
W/O:			W	ORK ORDER CHANGI	ES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
_						104				
								·		
Part No:		PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date:		
Resolution:			Disposition	Disposition: QA			QA: N/C Closed: Dat			
NCR:			WORK ORD	DER NON-CONFORMA	NCE (NCF	₹)	·			
DATE	STEP	Description of NC Section A	Corrective Action Sect Initial Action Description Chief Eng Chief Eng		on B Sign & Date			Approval Chief Eng	Approval QC Inspector	
			·				:			
							:			
	1									

NOTE: Date & initial all entries

H:\fORMS\Quality Assurance\approved QA\NCRWO RevE